

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 37369B			
Estimate Number	: 10442			
P.O. Number	:		Part Number	: D32623
This Issue	: 2/11/2008	S.O. No.	Drawing Number	: D3262 REV C
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: 1 /	Type	Drawing Revision	: C
Previous Run	: 36777B	: MACHINED PARTS	Material	:
Written By	: <u> </u>		Due Date	: 2/28/2008
Checked & Approved By	: <u> </u>		Qty:	10 Um: Each:
Comment	: Est. C 05.03.10	Removed P/O for liquid penetrant inspection K		
	J/JLM			



1.0 M6061T6B0500X06000 6061-T6 Bar .50" x 6.0"



Comment: Qty.: 0.9668 f(s)/Unit Total: 9.6684 f(s)
Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
(M6061T6B0.500x06.000)
Identify for D3262-3
Batch: 1103145 104236 *mi 200*

SF 08/02/20

10

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: 6.000" x 0.500" x 5.400" long Bar
Machine as per Folio FA457 and Dwg D3262
Identify for D3262-3
Deburr

8508/02/40

⑩

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per dwg D3262

S.L/H.A/bnd 08/03/12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L / B.A / gml 08/03/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3262-3 PAR #: N/A Fault Category: Prod/Machin Parts NCR: (Yes) No DQA: D Date: 08/03/19
 QA: N/C Closed: Date:

NCR: <u>37369B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/12	3.0	The origin was off by .200" on Y axis	<i>[Signature]</i>	Scrap and Replace. Qty 1 B: <u>M105145</u>	S.F. 08/03/14	<i>[Signature]</i> 08/03/15	<i>[Signature]</i>	<i>[Signature]</i> 08/03/15
08/03/18	3.0	1 part has tool mark in threaded hole	<i>[Signature]</i>	Scrap & replace Qty 1 B: <u>M105145</u>	J.L. 03/08/18	<i>[Signature]</i> 08/03/18	<i>[Signature]</i>	<i>[Signature]</i> 08/03/18

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:15:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 37369B

Part Number: D32623

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PH 08/03/18 (9)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BARCLOY

PH 08/03/18 (9)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PH 08/03/19

Job Completion



PH 2008/3/18 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 37369B
Description: Cap		Part Number: D3262-3
Inspection Dwg: D3262	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.073 x 45°	✓			
0.45	+/-0.030	0.450	✓			
R0.063	+/-0.010	R0.063	✓			
0.080	+/-0.010	0.080	✓			
0.33	+/-0.030	0.315	✓			
Ø5.005	+0.010/-0.000	Ø5.010	✓			
0.688	+0.015/-0.000	0.688	✓			
3.25	+/-0.005	3.248	✓			
0.875	+/-0.010	0.871	✓			
Ø0.516	+0.005/-0.000	Ø0.519	✓			
Ø5.165	+/-0.010	5.166	✓			
0.083	+0.015/-0.000	0.087	✓			
Ø0.580	+0.005/-0.000	Ø0.581	✓			

Measured by: H.A./m	Audited by: RQ	Prototype Approval:	N/A
Date: 08/03/12	Date: 08/02/18	Date:	N/A

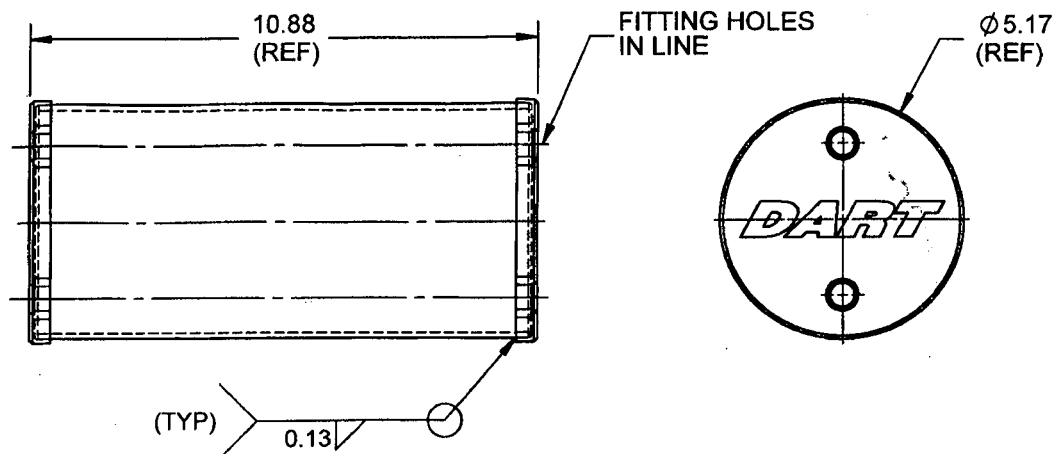
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM	BE



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

RELEASED

06.09.19 *[Signature]*

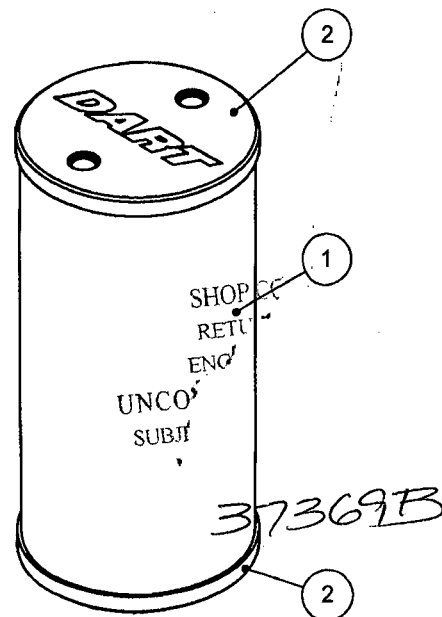


D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

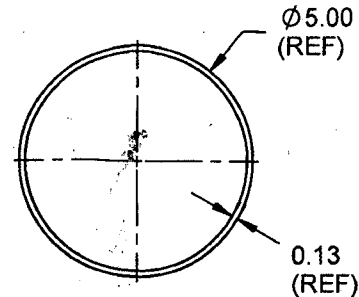
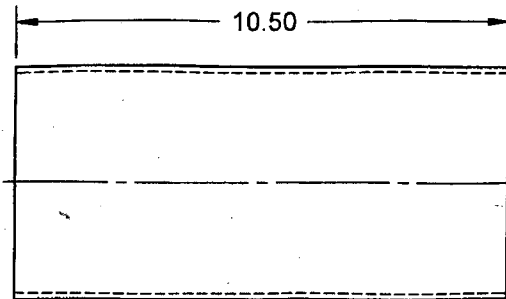


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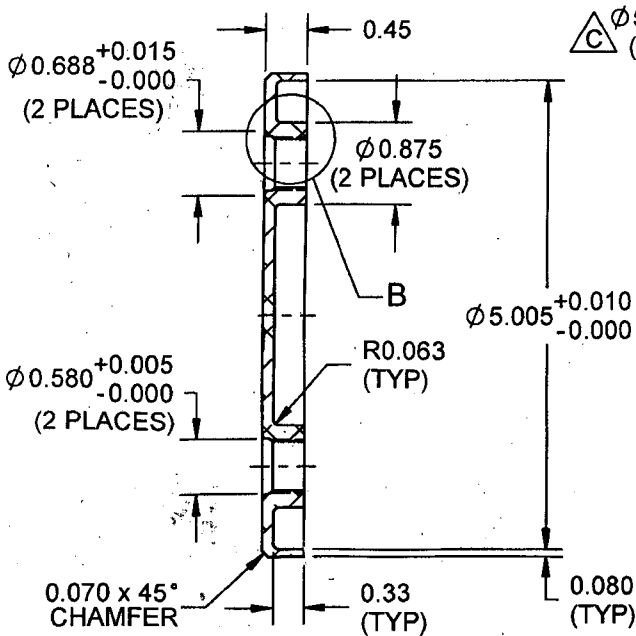
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DART

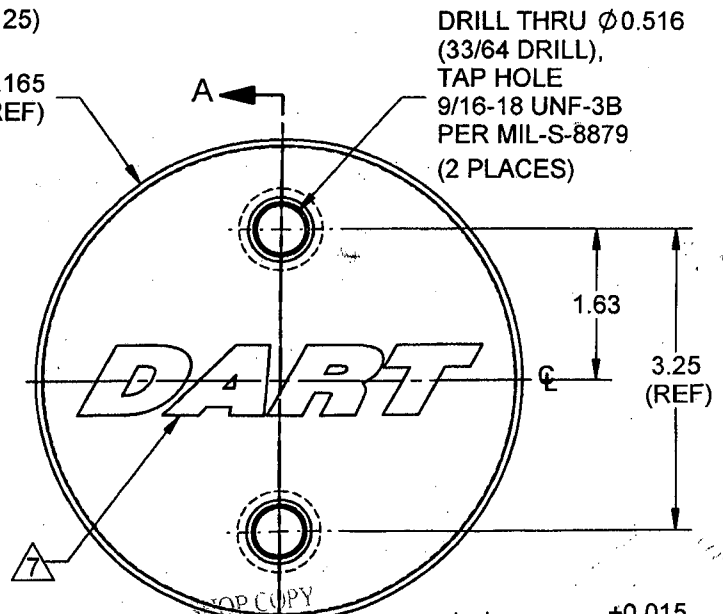
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31	TITLE FUEL PURGE CANISTER		
		SCALE 1:4	

**RELEASED***06.09.19***D3262-1 TUBE**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1:2



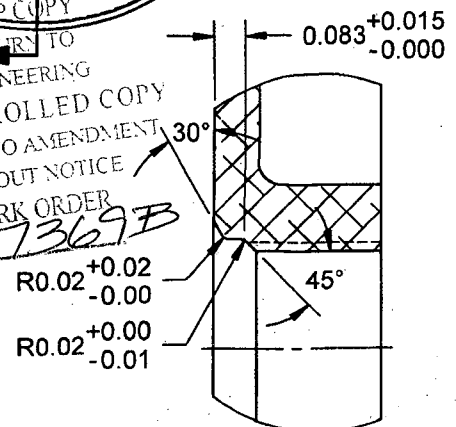
STOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37369B*

D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



DETAIL B
SCALE 2:1

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